

Date: Thursday, 12/20/2007 3:21:45 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36487
 Estimate Number : 12651
 P.O. Number :
 This Issue : 12/20/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run : 36445
 Written By :
 Checked & Approved By : 07.12.21
 Comment : Est Rev A New Issue 07-01-16 JLM
 est rev B revB dwg 07.04.18 ec

Drawing Name : R44 WEARPLATE

Part Number : D35651
 Drawing Number : D3565 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : ~~01R~~
 Material :
 Due Date : 1/20/2008

Qty: 40 Um: Each



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1418 sf(s)/Unit Total: 5.6700 sf(s)

304/316 .060 Sheet

Batch: 106653 B 08-1-2

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: C B 08-1-2

Prog Rev: C

2-Deburr if necessary B 08-1-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 D30093 CUP



Comment: Qty.: 3.0000 Each(s)/Unit Total: 120.0000 Each(s)

CUP

Batch: 36594 → 59x B37489 → 28x

B36431

29x

Date: _____
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 36487

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3565

2-Weld hard facing as per Dwg D3565

A/R 2059B Hard Coat rod

Batch:

using AT891 jig

PM106834

dy 08/03/19

(29x)

7.0

QC9

VISUAL WELDING INSPECTION

ENGINEERING
APPROVAL



Comment: VISUAL WELDING INSPECTION

QC#9 PD 08-03-19 / QC#5 & 08/03/20 (429)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 08/03/24

(29X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-03-24

(29)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

498 08/03/24 (29)

11.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

dy 08/03/24

(29)

Job Completion



POSITIVE RECALL


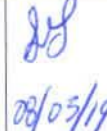

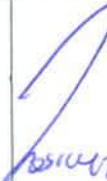

EFFECTIVE 07/27/21 AUTH 44

BASED 08.03.20 DATE 44

U 080324

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3565-1 PAR #: N/A Fault Category: Prod / FAB / Age NCR: Yes No DQA: D Date: 08/03/24
 QA: N/C Closed: D Date: 08/03/24

NCR: <u>36487</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/19	60	one Paul SCRAP welder tried to grind off welding mark. he ground off D30093 R.C. Hammer error		SCRAP and Destroy and Replace no Replace Qty. ①	 08/05/19	 08/03/19		 08/03/19

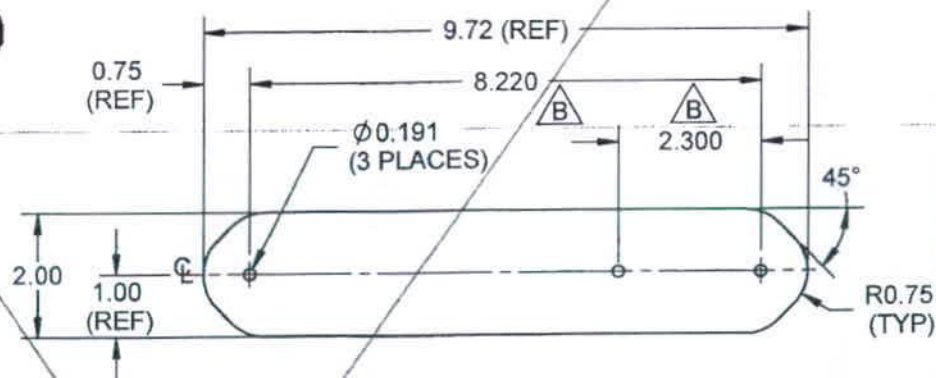
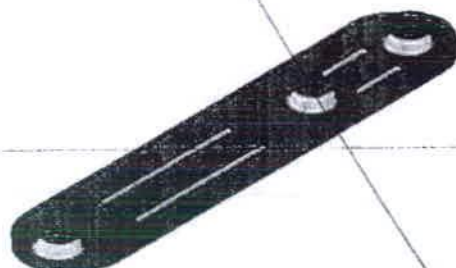
NOTE: Date & initial all entries





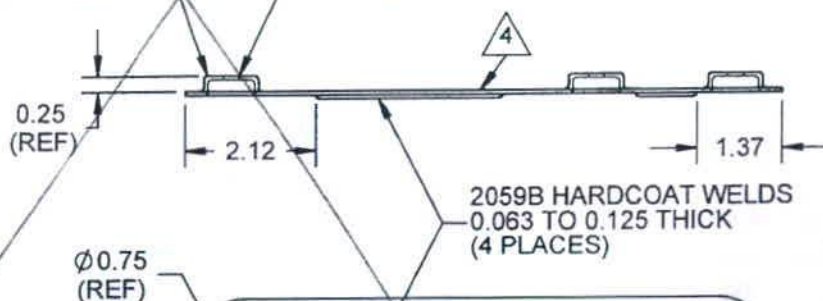
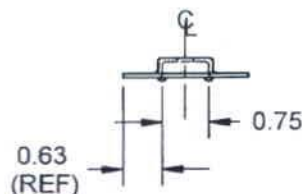
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3565	REV. B SHEET 1 OF 1
DATE 07.03.12	TITLE R44 WEARPLATE		SCALE 1:3
REV	DATE	DESCRIPTION	
A	07.01.09	NEW ISSUE	
B	07.03.12	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	

**D3565-1F FLAT PATTERN**

PUNCH $\phi 0.191$ HOLES WITH
 $\phi 0.75 \times 0.25$ DEEP PUNCH TOOL
(3 PLACES)

OPEN HOLES TO $\phi 0.257$ AFTER
PUNCHING OPERATION (IF NECESSARY)



$\phi 0.75$
(REF)

RELEASED

07.03.23

UNDER REVIEW

07.12.18

RE-DESIGN

D3565-1 R44 WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT ϕ

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